

Work Order ID 86797

86797

Page 1

July-06-12 2:53:37 PM

Item ID: D2989-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 7/06/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: Date: 12079 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9445 jig								
	cut cutouts with zip cut as per dwg D3832*								
	3- remove from jig and weld fable plate as per dwg D2989								
	A/R ER316 S.S. Rod Batch: <u>4123823</u>								
	*** PLEASE NOTE****								
	IF MAKING -043A :								
	ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER								
	DSI9473								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

1x DAS 43 9-89 14-01-08

 DAS 9 9-89 14-01-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2989-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Lid Assembly

Start Date: 7/06/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
Qty**Reject
Number**

**Insp.
Stamp**

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

SD 14-01-13

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

1 746 14-1-16

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	1ST COAT:								
	START TIME: 8:00								
	OVEN TEMPERATURE: 400°								
	FINISH TIME: 8:30								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
131	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
131									
HandFinish	Memo	0.00							
Hand Finishing	Mask lid prior to spray paint black and wing walk as per dwg								
	A/R Spray paint black batch: _____								

1 14-1-17 DAS 34 348

1 x 1 14/01/20

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 DAS 27 9.89 M1/1/12				1			
141 *141* Packaging Packaging	Identify as per dwg & Stock Location: <u>W10</u> Memo	0.00 0350-607-463/1390691				1x	1	14/01/20	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						14-01-21	

14-01-20

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Picklist Print

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Page 1

Work Order ID: 86797

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10.09.14 added pressure
 wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1 Rib		Manufactured	No			100	Each	8.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				83907		8							
✓ D2506 Label Plate		Manufactured	No			100	Each	12.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
				79197		1							
				82705		11							
✓ D2512-7 Rib		Manufactured	No			100	Each	8.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				53444		0							
				77522		4							
				81048		4							

B 99744 → 2x DAS 43 13-12-19 9-89

B 99826 DAS 43 13-12-19 9-89

B 107695 DAS 43 13-12-19 9-89

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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	5							

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Page 2

Work Order ID: 86797

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

✓ D2581 Manufactured No 100 Each 59.0000
Mounting Bracket

Location	Loc Qty	Loc Code
WA	37	
82506	2	
83230	3	
85436	8	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

² ~~B107768~~ → 2x

DAS
43 13-12-19
8-89

B105886 → 2x

✓ D2989-13 Manufactured No 100 Each 4.0000
Rib

Location	Loc Qty	Loc Code
WA	4	
84604	4	

² ~~B89403~~ → 2x

DAS
43 13-12-19
8-89

✓ D2989-19 Manufactured No 100 Each 10.0000
Rib

Location	Loc Qty	Loc Code
WA	10	
77519	4	
84603	6	

² ~~B86916~~ → 2x

DAS
43 13-12-19
8-89

✓ D3832-3 Manufactured No 100 Each 1.0000
Mesh (Lid)

Location	Loc Qty	Loc Code
WA035	1	
77520	1	

¹ ~~B86576~~ 14-01-07 DAS
43 8-89

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

Work Order ID: 86797
 Parent Item: D2989-041
 Parent Item Name: Basket Lid Assembly

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

✓ D3833-3 Manufactured No 100 Each 13.0000
 Mesh (Lid End)

Location	Loc Qty	Loc Code
WA	4	
81142	4	
WA035	9	
67460	9	

² B 99269 → 2x B 14.01.07
 DAS 43 9-89

/ D3836-041 Manufactured No 100 Each 4.0000
 Rib Assembly (Basket Lid, LH)

Location	Loc Qty	Loc Code
WA	4	
77515	4	

¹ B 90875 DAS 43 9-89 13-12-19

✓ D3836-042 Manufactured No 100 Each 4.0000
 Rib Assembly (Basket Lid, RH)

Location	Loc Qty	Loc Code
WA005	4	
77514	4	

¹ B 90080 DAS 43 9-89 13-12-19

/ D3852-041 Manufactured No 100 Each 6.0000
 Rib Assembly

Location	Loc Qty	Loc Code
WA005	6	
77512	2	
86042	2	
86154	2	

¹ B 87375 DAS 43 9-89 13-12-19

✓ D3852-042 Manufactured No 100 Each 5.0000
 Rib Assembly

Location	Loc Qty	Loc Code
WA	1	
77513	1	
WA005	4	
66089	1	
77513	1	
86043	2	

¹ B 86155 DAS 43 9-89 13-12-19

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	64						

Part No: 84 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	64							
	64							

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
REMOVED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86797

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-11/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.050 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.08.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS	DRAWING NO.	REV. D
CHECKED	DS	D2989	SHEET 1 OF 5
MFG. APPR.	DS	TITLE	SCALE
APPROVED	DS	BASKET LID ASSEMBLY	NTS
DE APPR.	DS	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

Dart Aerospace Ltd

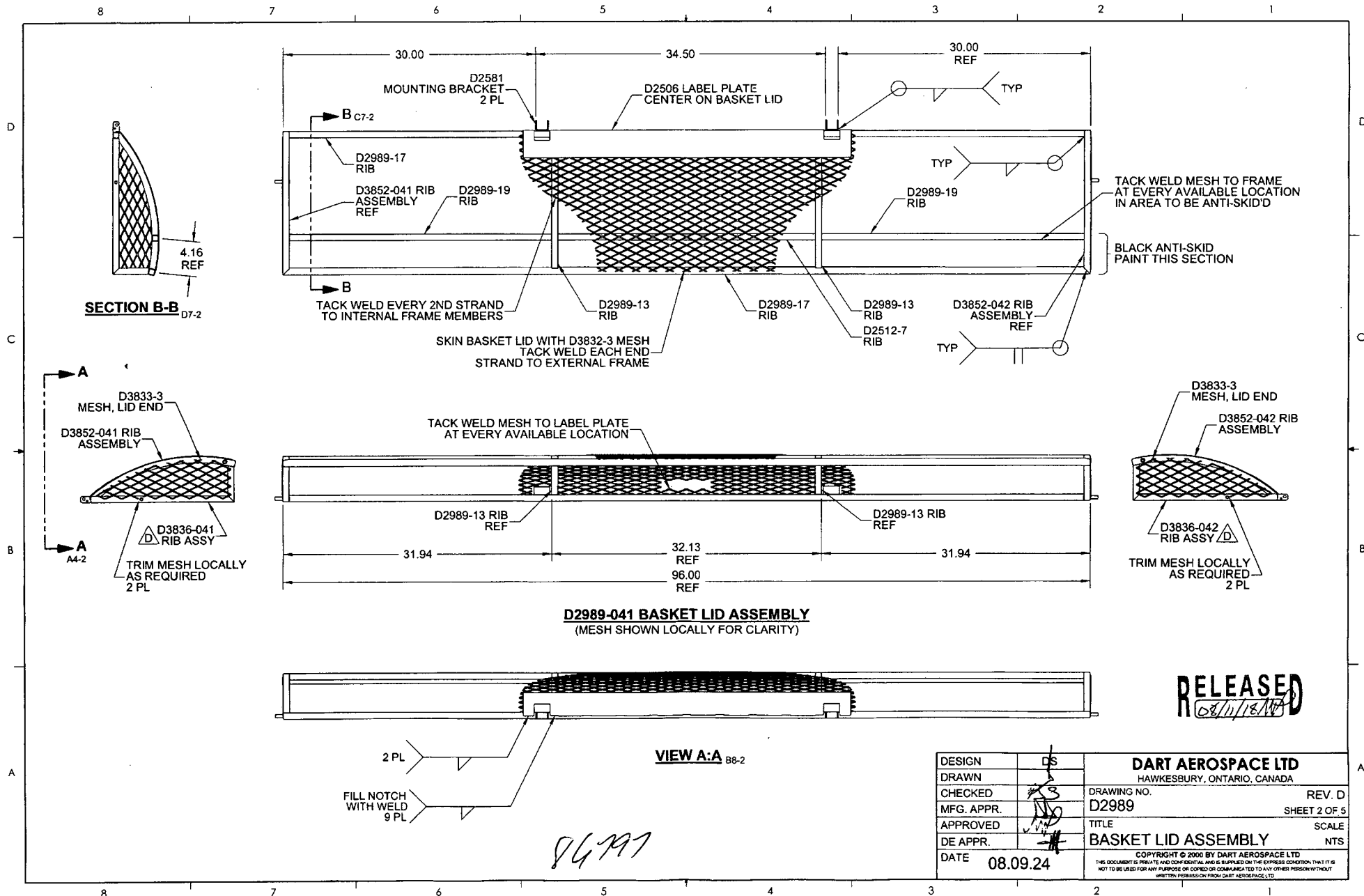
W/O:		WORK ORDER CHANGES					
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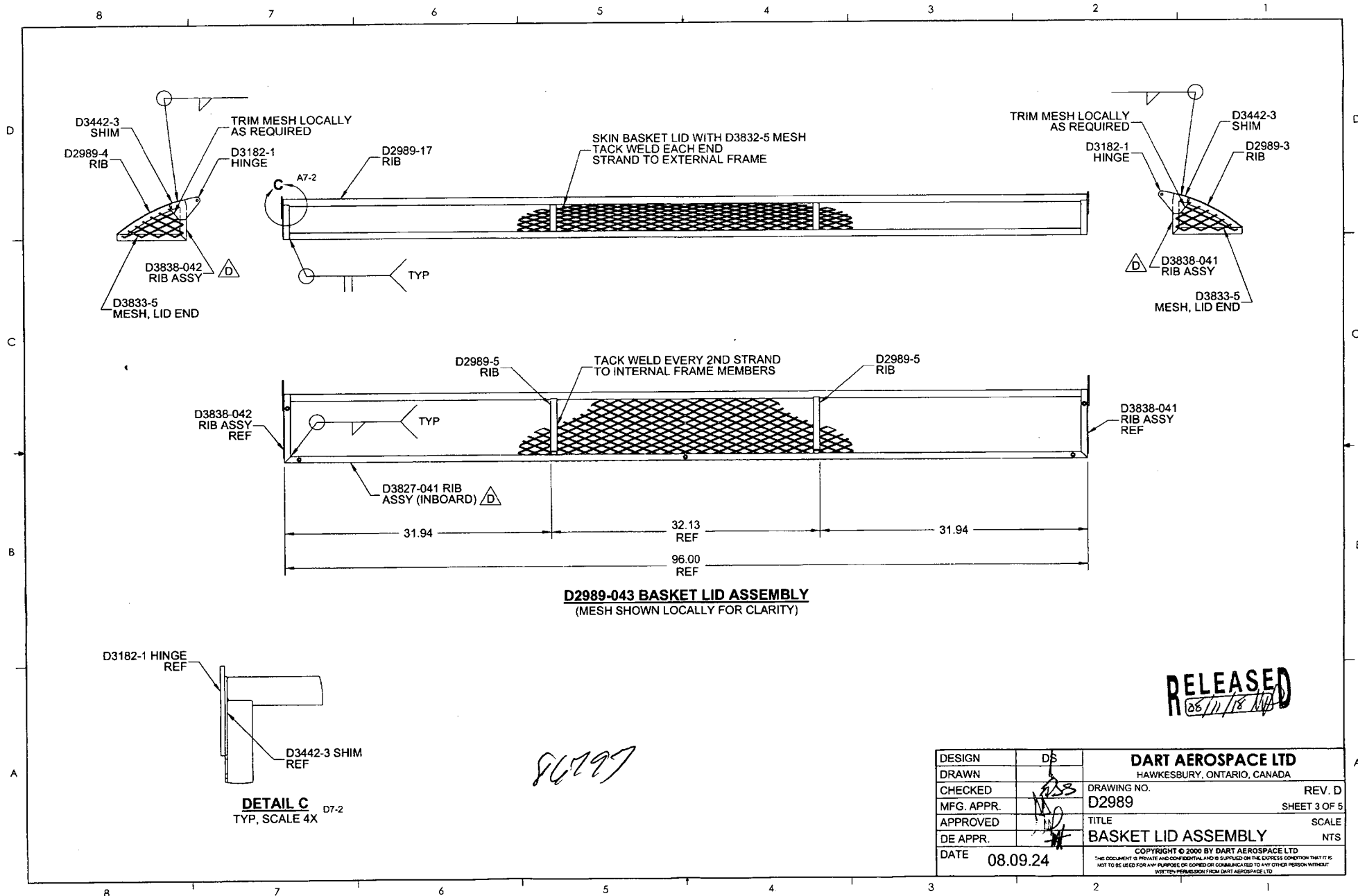
Dart Aerospace Ltd

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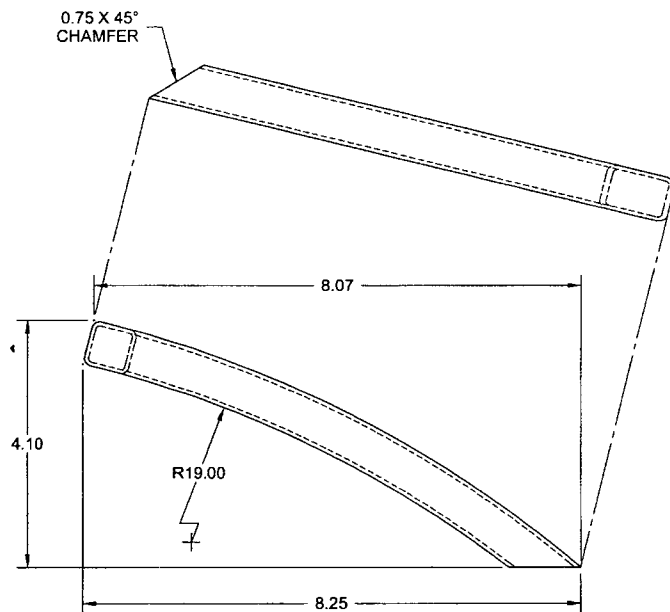
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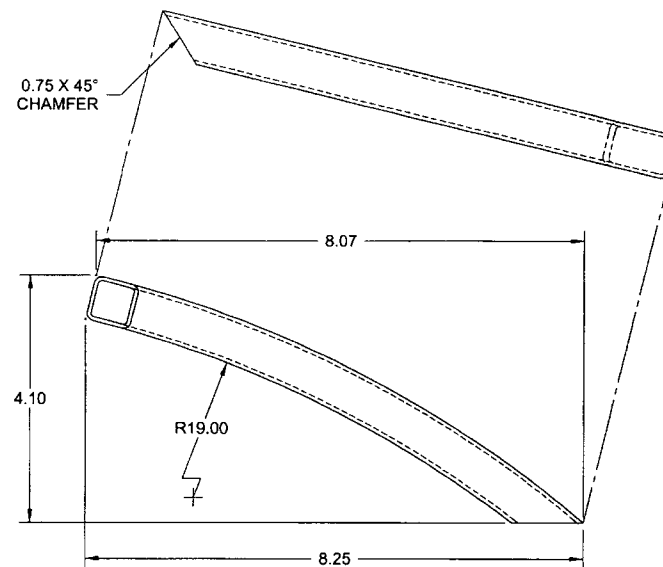
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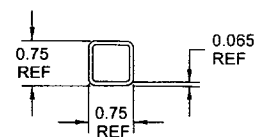


D2989-3 RIB



D2989-4 RIB

86797



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.		SHEET 4 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPARISON TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

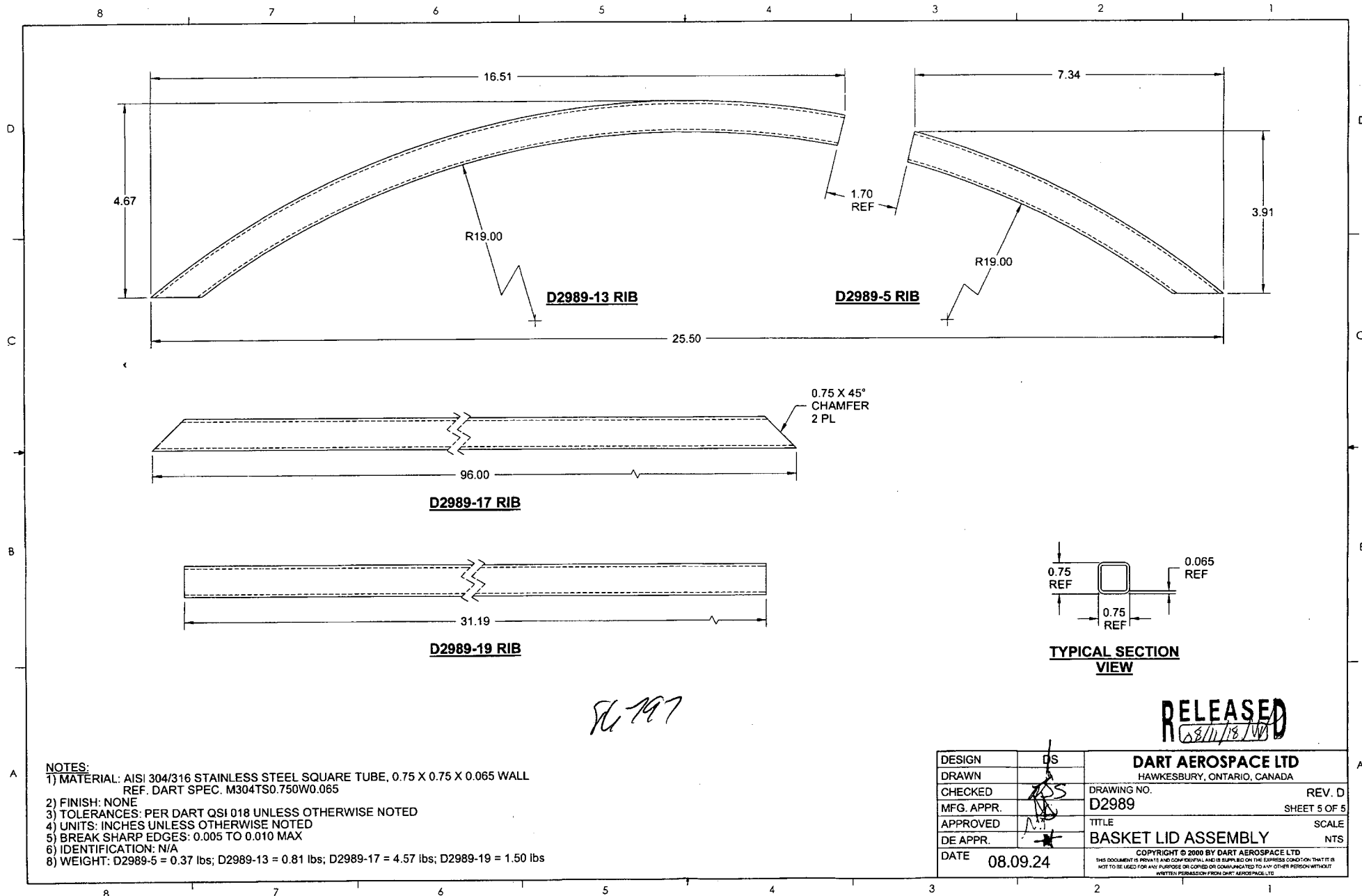
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DESIGN	DS	DART AEROSPACE LTD	
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. D2989	REV. D
MFG. APPR.	DS	SHEET 5 OF 5	
APPROVED	DS	TITLE BASKET LID ASSEMBLY	SCALE NTS
DE APPR.	DS	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	08.09.24	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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